



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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RB T103347-101
Job Sheet 194683



Part No: RB T103347-101

Job Qty: 1 pcs

Part Name: Cyclic Stick Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/7/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 6/28/19

Description: *Order 15899*

Type: SOLD

Note: DWG RB T103347-101 Rev 2 IPP Rev. A 19.05.06 New Issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	6/28/19		0.25	0.50	Small Fab - 1		<i>MLL</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	6/28/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
130	Packaging 3 - 1 - Stock - B4B	1 pcs	6/28/19		0.00	0.00	QC 5 - 30		<i>DAS</i> <i>40</i> <i>9-89</i>
							QC 5 - 40		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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CANADA
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Email: sales@dartaero.com
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Container No: S201897



Part: RB T103347-101

Job No: 194683

Serial No/Batch: S201897

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 07/31/19

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	6/28/19	0.00 0.00	QC 21 - FG - 21	NAG
				QC 21 - FG - 70	21 DAs
				QC 21 - SA - 53	9-59 JUL 31 2019

Part Op 100 - (Small Fab) Assemble as per drawing.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

GA-TBD

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
38 23-006C00-22-16	Bushing	1 Ea (1 ea)	100-Small Fab - 1	5181196
38 23-006C16-22-16	Bushing	2 Ea (2 ea)	100-Small Fab - 1	5181202
201 AN122721	Pin	1 (1 ea)	100-Small Fab - 1	5183561
201 AN44-6	Bolt	1 (1 ea)	100-Small Fab - 1	5183241
AN960PD416	Washer SEE PART NAS1149D0463K 019	3 Ea (3 ea)	100-Small Fab - 1	5183307
34 MS16555-041	Pin	2 Ea (2 ea)	100-Small Fab - 1	5183299
34 MS20074-04-06	Bolt	3 Ea (3 ea)	100-Small Fab - 1	5192446
GA 11 MS21042L5	Nut	1 Ea (1 ea)	100-Small Fab - 1	518121813-0
34 MS35426-29	Nut	1 Ea (1 ea)	100-Small Fab - 1	5184790
51263 NAS1149D0563J	Washer	1 Ea (1 ea)	100-Small Fab - 1	5174298
200 NAS6605-22	Bolt	1 Ea (1 ea)	100-Small Fab - 1	5183283
152F RB T1103347-103	TBD	1 (1 ea)	100-Small Fab - 1	5200819
150B RB T1103347-115	TBD	1 (1 ea)	100-Small Fab - 1	5192762
	TBD	1 (1 ea)	100-Small Fab - 1	5186350

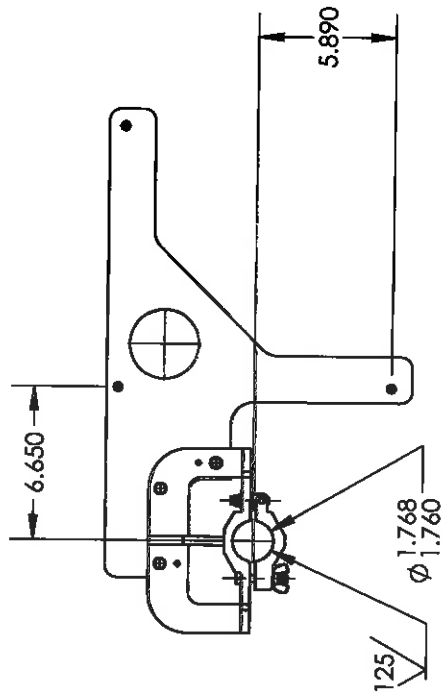
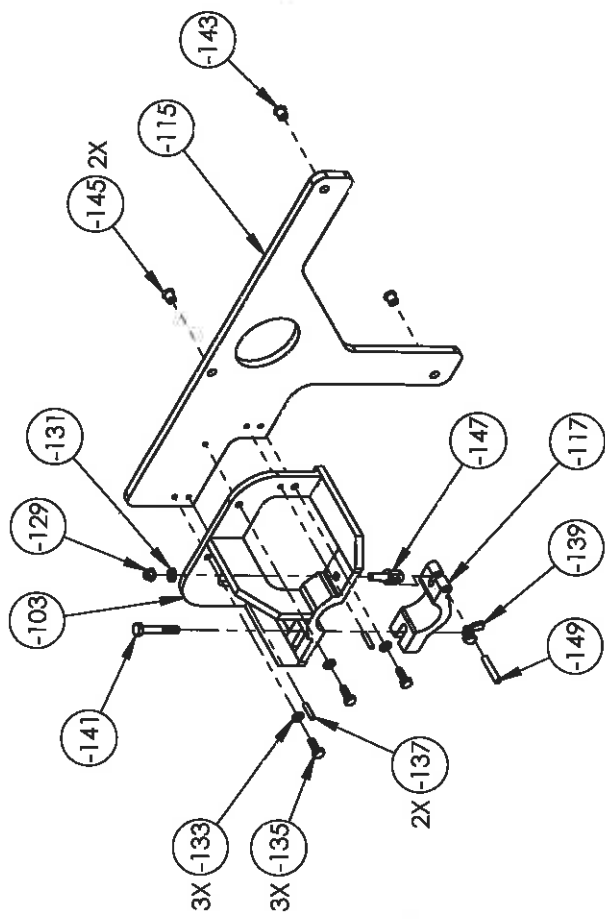
1146

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	23-006C00-22-16	1	0	0
	23-006C16-22-16	2	0	0
	AN122721	1	0	0
	AN44-6	1	0	0
	AN960PD416	3	0	0
	MS16555-641	2	0	0
	MS20074-04-06	3	0	0
	MS21042L5	1	652	0
	MS35426-29	1	0	0
	NAS1149D0563J	1	3,283	0
	NAS6605-22	1	0	0
	RB T1103347-103	1	0	0
	RB T1103347-115	1	0	0
	RB T1103347-117	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 5/7/19 11:42 AM Dart.lajeunesse.marie

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REVISIONS			
REV	ECR	DESCRIPTION	
1		REDRAWN IN SOLIDWORKS FROM TATTERED DRAWING. -115 CHD LIMIT DIM WAS Ø.1875-.1870 IS .1875-.1880. -117 CHD DIM WAS 4X R.04 IS 4X R.13. -137 CHD DIM WAS 2X R.06 IS 2X R.13.	DATE 6/16/2014
2	15-0197	+103 ADDED DIM (5.25). -115 ADDED ENGRAVE T/N. S/N. MADE IN USA NOTE.	INITIAL RJC
			APPROVED RJC



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WITHOUT NOTICE
WORK ORDER
NO. 194683 M.S
19-0507

NOTE:
REF. BELL T/N: T103347 REV A.



TITLE
CENTERING, PILOTS CYCLIC STICK
DWG NO. RB T103347-101
REV 2

DRAWN BY: DUERFELDT	
APPROVED: <i>D. Weil</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/32	
.XX ± .03 DECIMALS ± .005	
.X ± .1 ANGLES ± 5°	
1. BREAK ALL SHARP EDGES .015 x 45°	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL BELL 412	
SCALE 1:8	SHEET 1 OF 9

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
X	-103		-103	1	SUPPORT ASSEMBLY			2
	-115		-115	1	BASE	6061		3
	-117		-117	1	CLAMP	6061		4
1	-119		-119		BASE	6061		5
1	-121		-121		ARM	6061		6
1	-123		-123		ARM	6061		7
1	-125		-125		ARM	6061		8
1	-127		-127		HEAD	6061		9
	-129	B/O	-129	1	NUT	STEEL	5/16-24 SPENCER #MS21042L5	1
	-131	B/O	-131	1	WASHER	STEEL	Ø5/16 AIRCRAFT HARDWARE #AN960PD516	1
	-133	B/O	-133	3	WASHER	STEEL	Ø1/4 AIRCRAFT HARDWARE #AN960PD416	1
	-135	B/O	-135	3	BOLT	STEEL	1/4-20 AIRCRAFT HARDWARE #MS20074-04-06	1
	-137	B/O	-137	2	DOWEL PIN	STEEL	Ø3/16 X 7/8 AIRCRAFT HARDWARE #MS16355-641	1
	-139	B/O	-139	1	WING NUT	STEEL	5/16-24 AIRCRAFT HARDWARE #MS35406-29	1
	-141	B/O	-141	1	BOLT	STEEL	5/16-24 AIRCRAFT HARDWARE #NAS6605-22	1
	-143	B/O	-143	1	BUSHING	BRONZE	Ø3/8 O.D. AIRCRAFT HARDWARE #23-006C00-22-16	1
	-145	B/O	-145	2	BUSHING	BRONZE	Ø3/8 O.D. AIRCRAFT HARDWARE #23-006C16-22-16	1
	-147	B/O	-147	1	EYE BOLT	STEEL	5/16-24 AIRCRAFT HARDWARE #AN44-6	1
	-149	B/O	-149	1	DOWEL PIN	STEEL	Ø1/4 X 1-1/2 AIRCRAFT HARDWARE #AN12721	1
ASSY -103								

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		Engineering																																																													
Date: _____		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Water Jet Supplier Quality																																																									
Sequence #: _____		QTY Affected: _____		MRB (QS1042)																																																															
Description Work Order Deviation				Disposition																																																															
Completed By				Lead hand / Supervisor																																																															
QC / QA Coordinator																																																																			
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>				Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		FAULT CATEGORY																																															
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